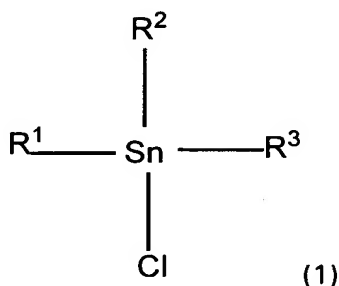


What is claimed is:

1. A process for the production of allyl succinic anhydride,
comprising reacting propene with maleic anhydride in the presence of
5 a catalytically effective amount of an organotin chloride catalyst.

2. The process of claim 1, wherein the organotin chloride
catalysts are those according to formula (1) below:



wherein

R^1 , R^2 are each independently alkyl, alkenyl, alkynyl, or phenyl,
 R^3 is Cl or alkyl, alkenyl, or alkynyl.

3. The process of claim 2, wherein R^1 and R^2 are each
independently $(\text{C}_1\text{-C}_6)$ alkyl or phenyl and R^3 is Cl or $(\text{C}_1\text{-C}_6)$ alkyl.

4. The process of claim 1, wherein the catalyst comprises one or
more compound selected from the group consisting of methyl tin
dichloride, dimethyl tin dichloride, ethyl tin dichloride, diethyl tin
dichloride, n-butyl tin trichloride, di-n-butyl tin dichloride, s-butyl tin
dichloride, di s-butyl tin dichloride, t-butyl tin dichloride, di t-butyl tin
dichloride, n-pentyl tin trichloride, di n-pentyl tin dichloride, n-hexyl tin
trichloride, di n-hexyl tin dichloride, and phenyl tin dichloride.

6. The process of claim 1 wherein the catalyst comprises one or more compound selected from the group consisting of n-butyl tin trichloride, diphenyl tin dichloride, divinyl tin dichloride, dimethyl tin dichloride, di n-butyl tin dichloride, and di t-butyl tin dichloride.

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7. The process of claim 1 wherein said catalyst comprises one or more compound selected from the group consisting of dimethyl tin dichloride, dibutyl tin dichloride, and butyl tin trichloride.

10 8. The process of claim 1 wherein the reaction is conducted at a temperature of less than about 200°C.

8. The process of claim 1 where the mixture conducted at a temperature of less than about 180°C.

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9. The process of claim 1, wherein the reaction mixture initially comprises substantially equimolar amounts propene and maleic anhydride.

20 10. The process of claim 1, wherein the reaction mixture initially comprises a molar excess of propene relative to the amount of maleic anhydride.

11. The process of claim 1, the reaction mixture initially comprises
25 a molar excess, of up to about 10 mole %, of propene relative to the amount of maleic anhydride.

12. The process of claim 1, wherein the process is carried out in a hydrocarbon solvent.

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13. The process of claim 1, wherein the process is conducted at a pressure of from about 100 to about 10,000 pounds per square inch above atmospheric pressure.
- 5 14. The process of claim 1, wherein the process is conducted in the presence of a free radical scavenger.